

Work Order ID 125792***125792***

Page 1

Wednesday, October 22, 2014 12:35:20 PM

Item ID: D350-689-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Installation

Start Date: 10/09/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-10-22 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI9588

B

IIN-D350-689

B

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-689-011 CHG006

DAS
06
9-89

NOV 12 2014

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

1x 8014-11-14
DAS
06
9-89
NOV 12 2014

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 125792

Wednesday, October 22, 2014 12:35:20 PM

125792

Page 2

Item ID: D350-689-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Installation

Start Date: 10/09/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC4- 100% Inspect kits for completeness

0.00

DAS
06
9-89***120***

QC

Memo

0.00

Quality Control

NOV 12 2014

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-689-011

Location: 638

PPP Rev: _____

DAS
06
9-89

NOV 12 2014

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14/11/14
①4-11-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Wednesday, October 22, 2014 12:35:20 PM

Page 1

Work Order ID: 125792

125792

Parent Item: D350-689-011

D350-689-011

Parent Item Name: Dual High Back Seat Installation

Start Date: 10/09/14

Required Date: 10/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B03.05.09Reformat; Modify Step 1KJ/RF IPP Rev:C chg003
per DSI 9498 DD 10.02.11 verified by:JLM IPP REV:D 11.11.24 AS PER
ECN11-674 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-689-013	9-89	Manufactured	No			110	Each	0.0000	1	1			DAS 26 9-89
D350-689-013									**	125840			
Floor Provisions													
D350-689-041		Manufactured	No			110	Each	0.0000	1	1			DAS 26 9-89
D350-689-041									**	128719			
Dual High Back Seat Assembly													
D3018-1		Manufactured	No			110	Each	7.0000	1	1			
D3018-1									**				
Seat Cushion													

DAS
06
9-89

Location	Loc Qty	Loc Code
st196a	4	
116961	4	
ST264A	2	
106774	1	
110970	1	
ST638	1	
120768	1	

DAS
46
9-89

D3019-1 Manufactured No

D3019-1

Back Cushion

Location	Loc Qty	Loc Code
ST202A	4	
117042	4	
ST639	2	
120370	2	

DAS
46
9-89

DAS
06
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 1
REF. TCCA STC: SH02-33
REF. FAA STC: SR01620NY
REF. EASA STC: EASA.IM.R.S.01453
REF. TCA STC: 2005S03-09

1.0 PURPOSE

For D350-689-011/-013 at CHG 006/005 and later and D350-689-021/-023 Kits at CHG 005/004 and later, the D3026-1 Channel has been replaced with the D4575-1 Beam and D4575-3 Doubler and the D3234-3 Doubler has been removed. Consequently, the installation instructions for D350-689-011/-013 at CHG 006/005 and D350-689-021/-023 at CHG 005/004 are updated per Section 2.0 of this Service Instruction. The parts list update is shown in Section 4.0 of this Service Instruction. There is a negligible change to the weight and balance.

2.0 INSTALLATION CHANGES FOR D350-689-013

Section 3.9, *INSTALLATION OF D350-689-013 FLOOR PROVISIONS KIT* (pages 4 and 5 of IIN-D350-689), is changed as follows:

Item 3.3.15 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.3.15 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel & D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel & D3032-1 Spacer as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.3.17 is:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer to floor using MS20426AD4 rivets.

Item 3.3.17 was:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D3026-1 Channel and D3032-1 Spacer using MS20426AD4 rivets.

Item 3.3.22 is:

Rivet D3234-1 Doubler to D3025-1 Beam as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.3.25.

Item 3.3.22 was:

Rivet D3234-1 Doubler to D3025-1 Beam and D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.2.25.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

B	CHANGES TO -013 KIT INSTALLATION. REF: CIR12-12.	MB	12.11.09
A	NEW ISSUE	MB	11.12.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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WORK ORDER
125392 MJS
14-10-22

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RETURN TO
ENGINEERING

3.0 INSTALLATION CHANGES FOR D350-689-023

Section 3.9, *INSTALLATION OF D350-689-023 ENERGY ATTENUATING FLOOR PROVISIONS KIT* (pages 8 and 9 of IIN-D350-689), is changed as follows:

Item 3.9.8 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 2 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam and D4575-3 Doubler. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.9.8 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.9.10 is:

Attach D4575-1 Beam and D4575-3 Doubler to floor using qty (14) MS20426AD4 rivets.

Item 3.9.10 was:

Attach D4575-1 Channel to floor using qty (14) MS20426AD4 rivets.

Item 3.9.12 is no longer applicable:

~~Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.~~

Item 3.9.12 was:

Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

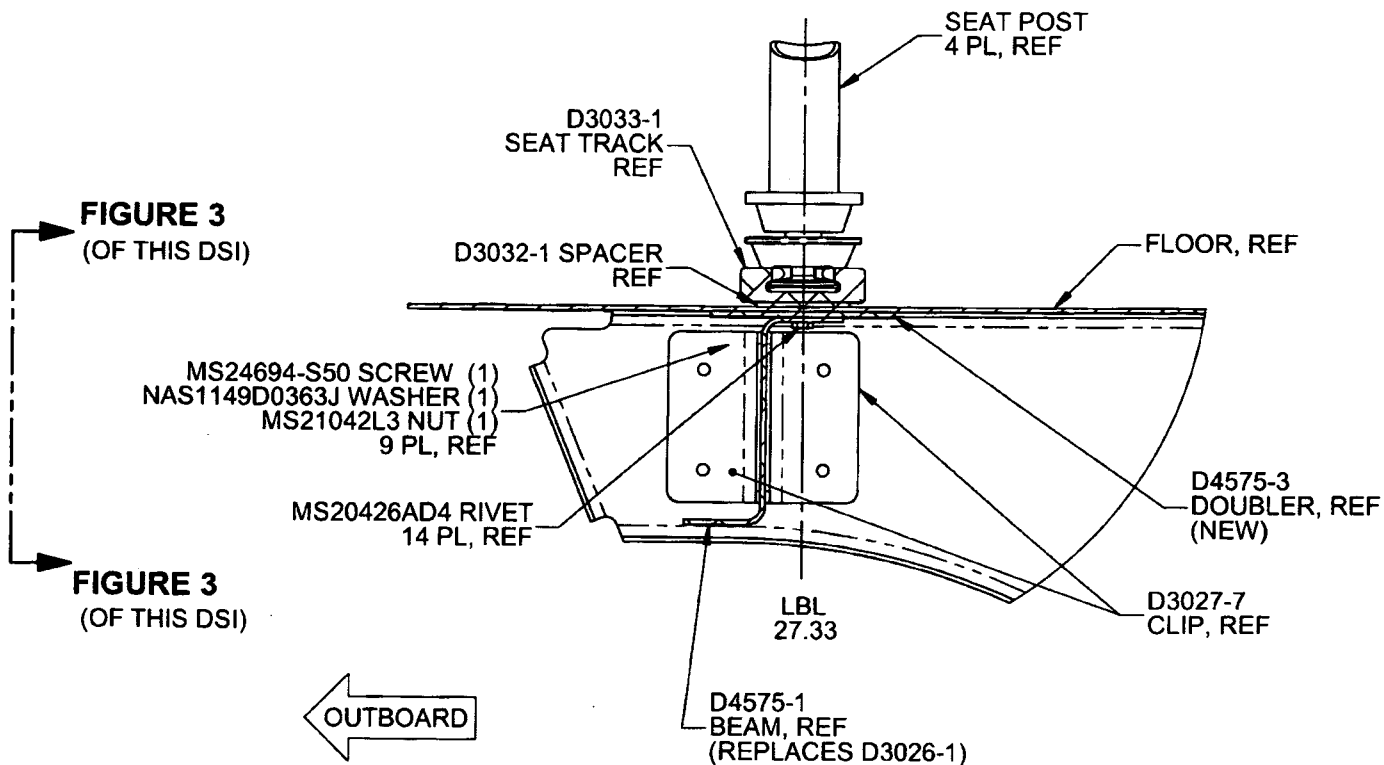
APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



CROSS SECTION VIEW F-F/M-M: From Figures 5 and 7 (IIN-D350-689)
CROSS SECTION VIEW F-F/M-M: From Figures 25-5 and 25-7 (ICA-D350-689)

FIGURE 1: UPDATES TO CROSS SECTIONS F-F AND M-M
 With reference to Figures 5 and 7 of IIN-D350-689
 (Figures 25-5 and 25-7 of ICA-D350-689)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
 D. SHEPHERD (DE # 02)

DATE: 12.11.09
 CERT. NO.: SH02-33
 ISSUE NO.: 1

DESIGN	B	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TH	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 3 OF 6
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

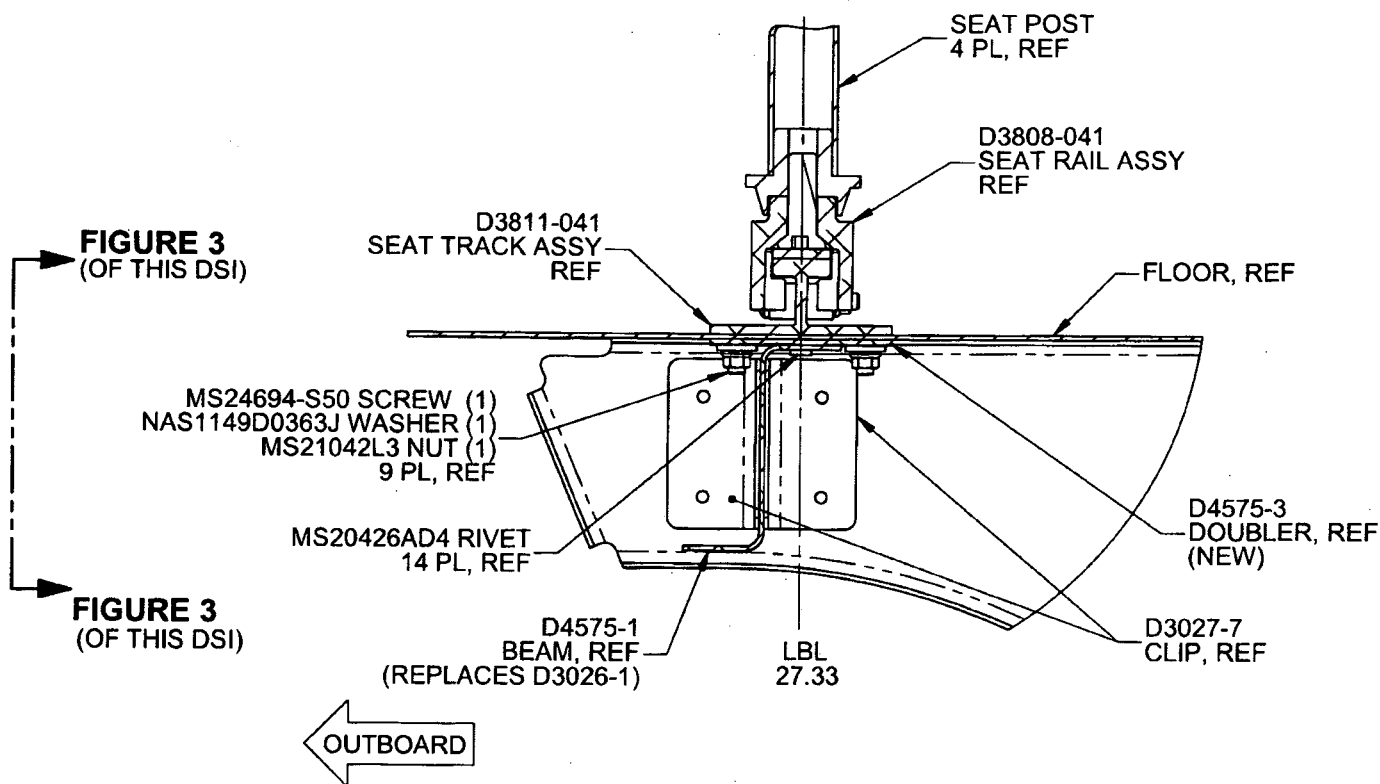


FIGURE 21: Cross Section View T-T from Figure 19 (IIN-D350-689)
FIGURE 25-21: Cross Section View T-T from Figure 25-19 (ICA-D350-689)

FIGURE 2: UPDATES TO FIGURE 21 (IIN-D350-689) AND 25-21 (ICA-D350-689)
 With reference to Figures 19 and 20 of IIN-D350-689
 (Figures 25-19 and 25-20 of ICA-D350-689)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 12.11.09
 CERT. NO.: SH02-33
 ISSUE NO.: 1

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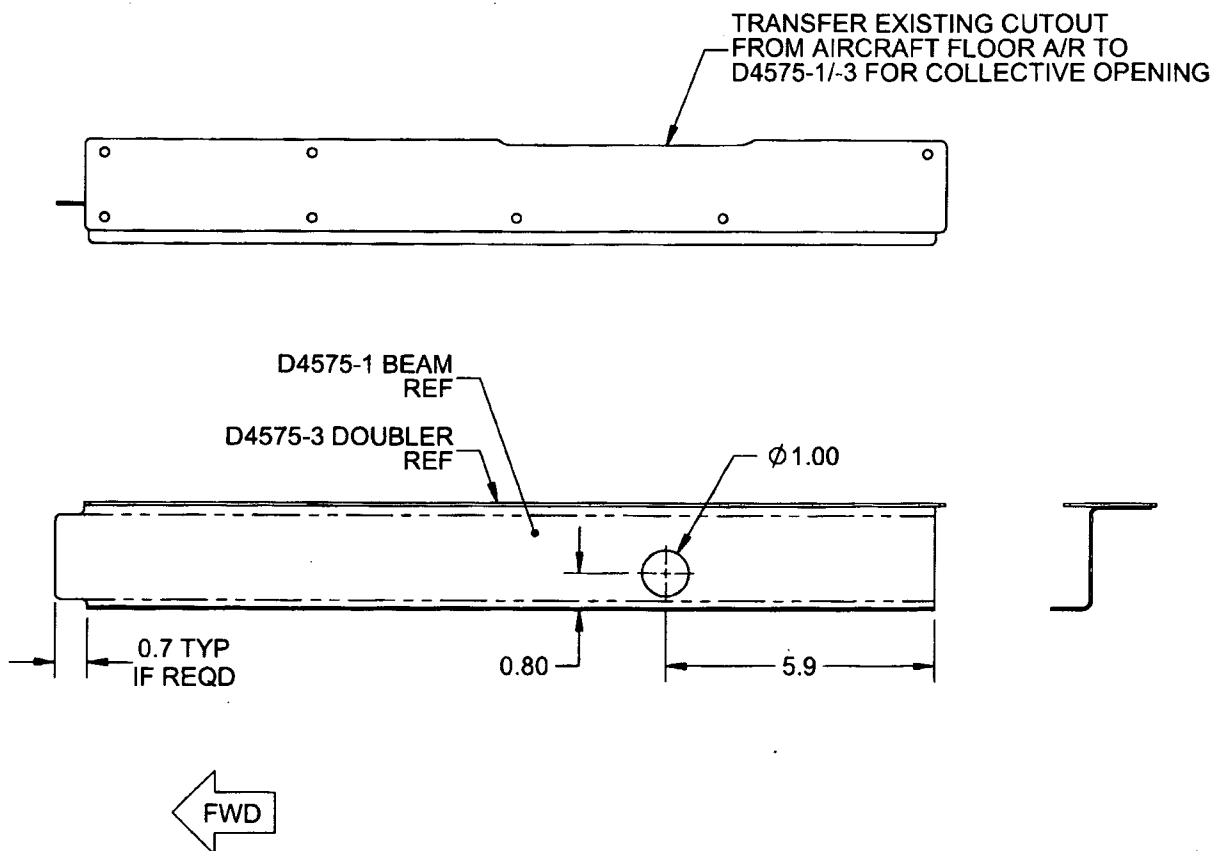


FIGURE 3: RELIEFS ON D4575-1/-3
(ONLY D4575-1/-3 SHOWN FOR CLARITY)
VIEW LOOKING INBOARD

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *M. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 12.11.09
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4.0 PARTS LIST CHANGE

The parts list of D350-689-021/-023 at CHG 005/004 or later is amended as follows:

5. PARTS LIST (IIN-D350-689) 25.10 PARTS LIST (ICA-D350-689)

IS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
									D3026-1	CHANNEL (REMOVED)
									D3234-3	DOUBLER (REMOVED)
	1					1			D4575-1	BEAM (REPLACES D3026-1)
	1					1			D4575-3	DOUBLER (NEW)

WAS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
	1					1			D3026-1	CHANNEL
	1					1			D3234-3	DOUBLER

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.11.09
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Work Order ID 125792

125792

Page 1

Wednesday, October 22, 2014 12:35:20 PM

Item ID: D350-689-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dual High Back Seat Installation

Start Date: 10/09/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-10-22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9588	B								
IIN-D350-689	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-689-011 CHG006								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

MCS 14-10-31

sf